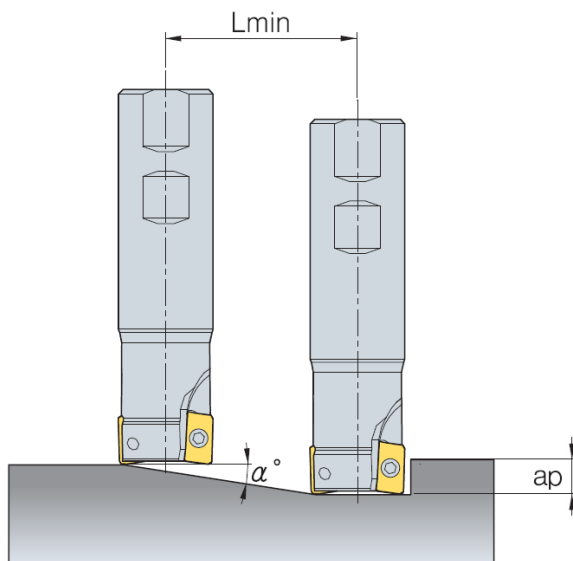


Technical Details

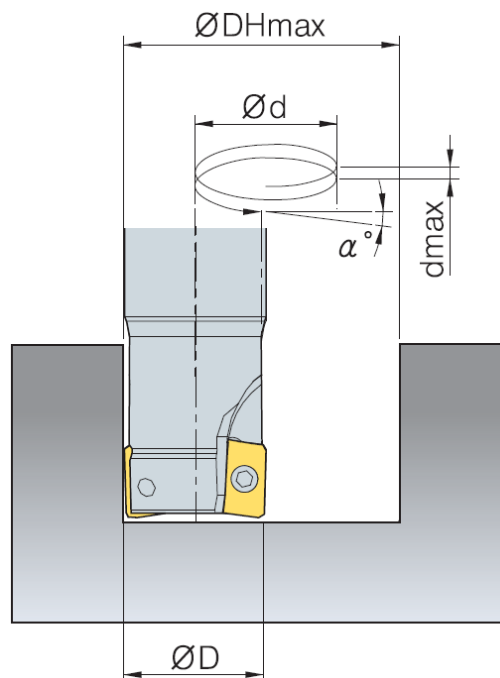


1. Ramping

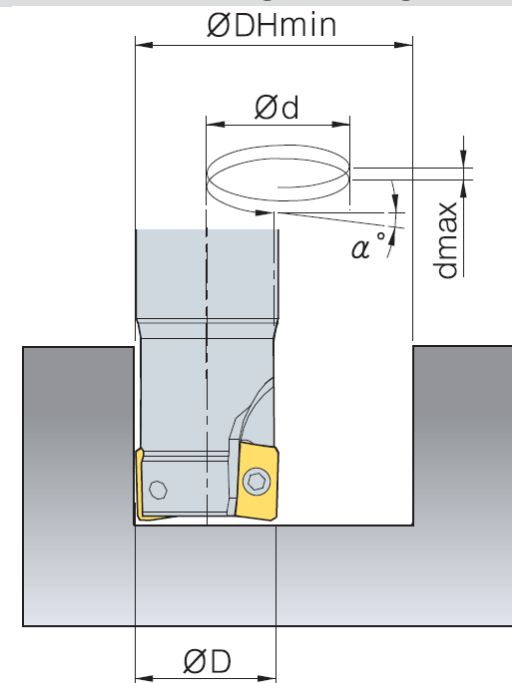


* In ramping and helical machining, use coolant and air. $L_{min} = ap / \tan(\alpha^\circ)$

2. Helical Cutting Blind Holes



3. Helical Cutting Through Holes



(mm)

Part #	Tool Diameter ØD(min)	ap	1. Ramping		2. Helical Cutting for Blind Holes				3. Helical Cutting for Through Holes	
			Max. Rake Angle α°	L min	Min. Machining Dia. ØDHmin	Max. pitch dmax	Max. Machining Dia. ØDHmax	Max. pitch dmax	Min. Machining Dia. ØDHmin	Max. pitch dmax
01-0295	12	5	4.9	58	22.8	2	21.6	1.9	17	1.5
01-0296	16	5	3.3	87	30.8	1.8	29.6	1.7	25	1.4
01-0297	20	5	2.5	115	38.8	1.7	37.6	1.6	33	1.4



Technical Details



Chip Breaker	Cutting Edge Shape	Recommended chip breaker and grade by work piece material (✓ 1st recommendation)									
		P				M		K		N	
		Low carbon steel Mild steel		High Carbon steel Alloy steel		Stainless steel		Cast iron		Non-ferrous metal	
		C.B.	Grades	C.B.	Grades	C.B.	Grades	C.B.	Grades	C.B.	Grades
-		-	-	-	-	-	-	-	-	✓	✓ HN25A
MHS		✓	✓ HU30	✓	✓ HU30	✓	✓ HU30	✓	✓ HU30	-	-